

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014400**Date Inspected:** 22-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China

CWI Name:	Mr.Zhao Chen Sun/An Qing Xian			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Tower	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

BAY# 10

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Lift 1 Shear Plate A27. The weld designations reviewed are as follows:-

ED1-A27B/E-22,26,27,30,36,40,43,50.

IN PROCESS INSPECTION:-

BAY#11

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA4-10-119M-1-9A located on Strut Plate. Welder is identified as 046769.ZPMC QC is identified as Mr.Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2212-TC-U5b.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ED1-STSA4-6-135M-1-17 located on Strut Plate. Welder is identified as 040724.ZPMC QC is identified as Mr. Zhu Yuan Yuan. The welding variables recorded by QC appeared to

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comply with the WPS-B-T-2113.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA4-6-127M-1-20 located on Strut Plate. Welder is identified as 046709.ZPMC QC is identified as Mr. Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WD1-A21A/B-22 located on Shear Plate Bearing Stiffener. Welder is identified as 040609.ZPMC QC is identified as Mr.Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.Please see the attached picture.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WD1-A21A/B-23 located on Shear Plate Bearing Stiffener. Welder is identified as 040609.ZPMC QC is identified as Mr.Xu Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.Please see the attached picture.

This QA inspector observed the following work in progress:

SAW welding of weld joint no: GTSA5-B/G-3B located on Grillage Top Erection Plate. Welder is identified as 042195.ZPMC QC is identified as Mr.Shao Hai Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

This QA inspector observed the following work in progress:

SAW welding of weld joint no: GTSA5-B/G-6B located on Grillage Top Erection Plate. Welder is identified as 044550.ZPMC QC is identified as Mr.Shao Hai Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.



Summary of Conversations:

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No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Pandaram	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
